

# Work Order ID 120565

**\*120565\***

Page 1

Wednesday, June 04, 2014 3:08:40 PM

Item ID: D2573 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, Aft, Out  
 Start Date: 6/04/14 Start Qty: 12.00 **\*12\*** Cust Item ID:  
 Required Date: 6/04/14 Req'd Qty: 12.00 **\*12\*** Customer:  
 Reference:

Approvals: Process Plan: MLS Date: 14-06-09 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2573	F

100 0.00 **\*100\*** HAAS CNC VERTICAL MACHINING #1  
 HAAS 1 Memo 0.00  
 HAAS CNC vertical machine #1 Program Batch No. 120565  
 Double check by: [Signature]  
 12  $\phi$  DAS 37 14-08-20  
 02 14-08-20  
 9-89

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

110 0.00 **\*110\*** CONVENTIONAL MILLING MACHINE  
 Mill Conv Memo 0.00  
 Conventional Milling Machine Machine keyway as per dwg D2573 & D2574  
 12  $\phi$  DAS 37 14-08-20  
 9-89

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Wednesday, June 04, 2014 3:08:40 PM

**\*120565\***

Page 3

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

Stop \*NS2\*

**Start Date:** 6/04/14      **Start Qty:** 12.00      **\*12\***

**Cust Item ID:**

**Required Date:** 6/04/14      **Req'd Qty:** 12.00      **\*12\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:**                      **Date:**                      **Tooling:**                      **Date:**

**Stop** **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

[illegible]

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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# Picklist Print

Wednesday, June 04, 2014 3:08:40 PM

Page 1

Work Order ID: 120565

**\*120565\***

Parent Item: D2573

**\*D2573\***

Parent Item Name: Saddle, Aft, Out

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	78.0000	1	12			

**\*D6101-007\***

**\*\***

Saddle Billet

Location

Loc Qty

Loc Code

MAT044

78

110314

8

114363

13

116083

25

119005

2

119623

30

121646

12 x

JFC 2014-08-10

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	120565
<b>Description:</b> Saddle, Aft Outboard	<b>Part Number:</b>	D2573
<b>Inspection Dwg:</b> D2573 Rev. F		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.001	8.001	8.001		
F	0.490	0.510		0.503	0.509	0.506	0.506		
G	0.257	0.262		0.260	0.260	0.260	0.260		
H	0.375	0.380		0.378	0.378	0.378	0.378		
I	0.490	0.510		0.499	0.500	0.498	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.565	0.568	0.567	0.565		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.125	0.125	0.125	0.125		
Q	0.115	0.135		0.125	0.126	0.126	0.125		
R	0.240	0.260		0.254	0.253	0.253	0.257		
S	0.115	0.135		0.170	0.124	0.126	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.240	0.236	0.236	0.238		
W	0.115	0.135		0.134	0.124	0.124	0.124		
X	0.308	0.313		0.311	0.310	0.311	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.362	0.362	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.627	0.627	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.251	0.248	0.248	0.249		
AE	1.500	1.520		1.512	1.517	1.518	1.517		
AF	0.115	0.135		0.125	0.125	0.125	0.125		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.251	0.248	0.249	0.250		
AI	2.000	2.020		2.002	2.007	2.005	2.004		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject

Measured by:	37 9-89	DAS 02
Date:	14.08.14.	9-89

Audited by:	
Date:	14/08/21

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

Summary

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 120565
<b>Description:</b> Saddle, Aft Outboard	<b>Part Number:</b> D2573
<b>Inspection Dwg:</b> D2573 Rev. F	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.003	8.001	8.001		
F	0.490	0.510		.499	.501	.498	.500		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.5015	.499	.499	.498		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.570	.567	.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.124	.125	.124	.125		
R	0.240	0.260		.249	.250	.254	.253		
S	0.115	0.135		.125	.125	.124	.124		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.240	.240	.241	.240		
W	0.115	0.135		.125	.126	.125	.125		
X	0.308	0.313		.310	.309	.309	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.362	.362	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.626	.628	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.249	.250	.251	.251		
AE	1.500	1.520		1.516	1.517	1.517	1.516		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.249	.249	.250	.250		
AI	2.000	2.020		2.001	2.003	2.002	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

37

Measured by:	9-89
Date:	14.08.15

Audited by:	CJL
Date:	14/08/21

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

Small

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 120565
<b>Description:</b> Saddle, Aft Outboard	<b>Part Number:</b> D2573
<b>Inspection Dwg:</b> D2573 Rev. F	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9 1	10 2	11 3	12 4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.001	8.000	8.001		
F	0.490	0.510		.500	.498	.499	.500		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.4995	.498	.500	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.568	.569	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.126	.125	.124	.125		
R	0.240	0.260		.253	.253	.254	.253		
S	0.115	0.135		.125	.125	.125	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.240	.241	.241	.241		
W	0.115	0.135		.125	.125	.124	.125		
X	0.308	0.313		.309	.308	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.362	.362	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.626	.626	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.249	.249		
AE	1.500	1.520		1.517	1.516	1.516	1.517		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.251	.250	.249	.249		
AI	2.000	2.020		2.008	2.008	2.007	2.007		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	37
Date:	14.08.19

Audited by:	[Signature]
Date:	14/08/21

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	[Signature]

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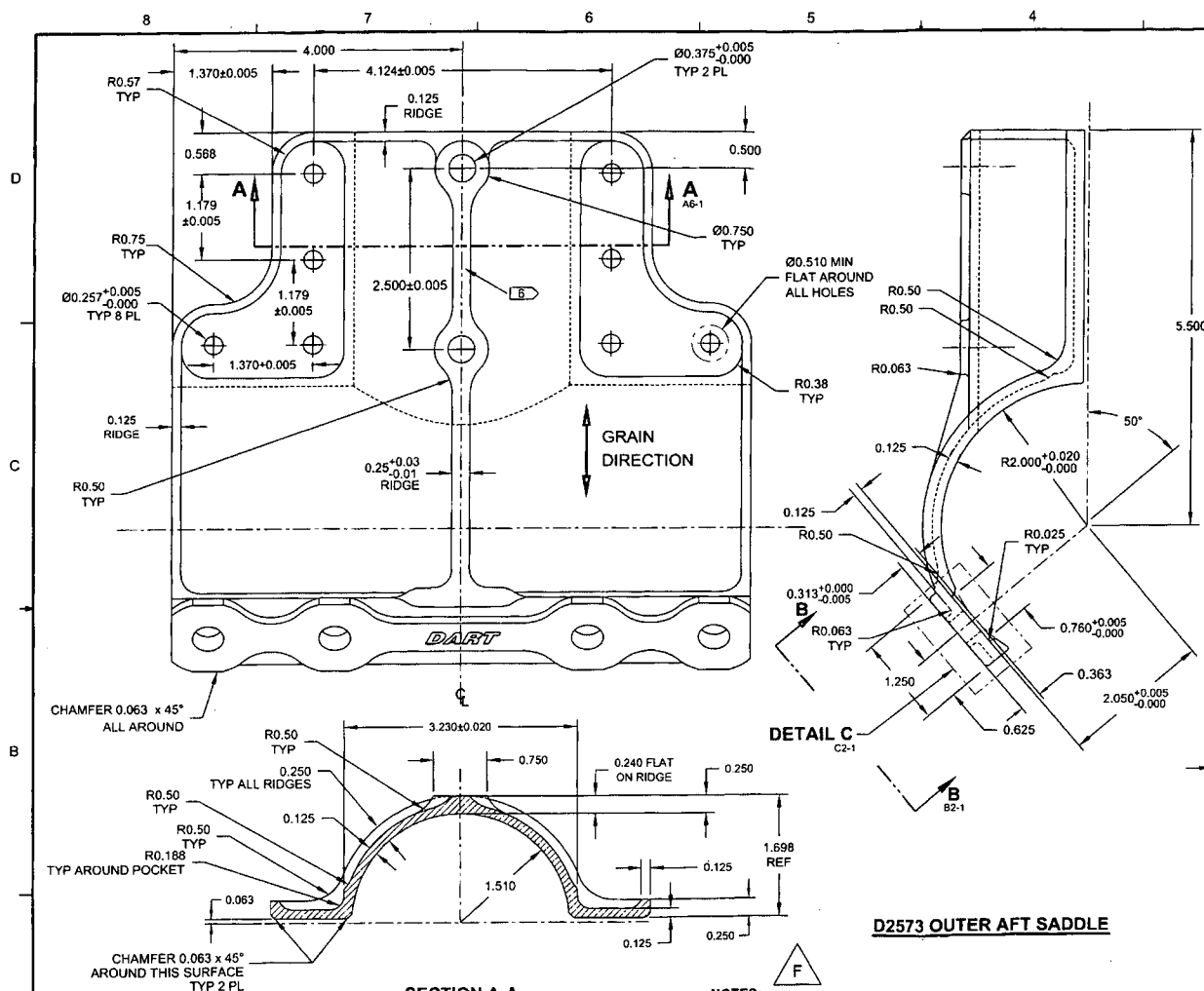
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 120565 MJS

140600

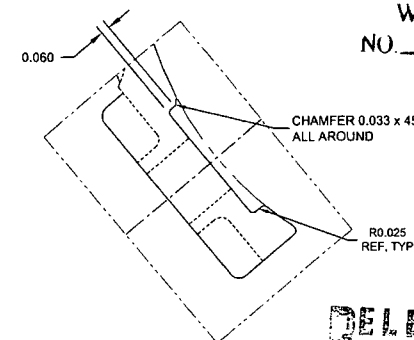
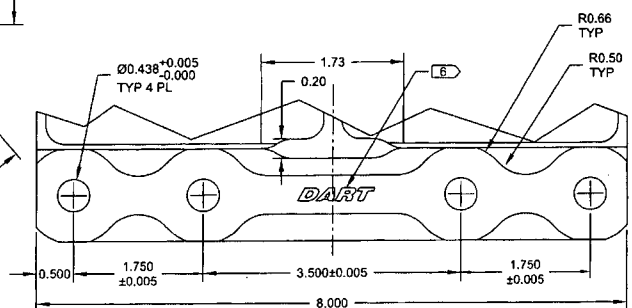


SECTION A-A D6-1

D2573 OUTER AFT SADDLE

## NOTES:

- 1) MATERIAL: 7075-T7351 PER QQ-A-250/12 (REF DART SPEC. D6101-007)
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D2573" AND B/N PER DART QSI 044 6.3  
(CNC ENGRAVING) USE MAX DEPTH OF 0.010 WITH MIN TOOL RAD OF 0.010  
ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD OF 0.125
- 7) WEIGHT: 1.07 lbs

DETAIL C C5-1  
SCALE 2X

VIEW B-B B5-1

F	D6101-007 WAS D6102-001 REF NCR12-1832	SFM	12.11.13
E	ADD CHAMFER ON RIDGE, NOTE 5	PH	05.07.13
D	ADD RIDGES; TIGHTEN TOLERANCES	CP	02.09.06
C	INCP. DEO 9123/9079/9120 ADD DIMENSIONS PER TSR A1177	CP	99.10.22
B	ADD GRAIN DIR., 0.438 WAS 0.425	CW	96.12.02
A	NEW ISSUE	BW	96.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SFM		
CHECKED		DRAWING NO.	REV.F
MFG. APPR.		D2573	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		OUTER AFT SADDLE	NTS
DATE	12.11.13	COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	